

Work Order ID 63785

Monday, November 15, 2010 8:29:12 AM

Page 1

Item ID: D2435

Accept

Revision ID:

Item Name: Bearpaw, 206

Start Date: 11/12/2010 Start Qty: 8.00

Required Date: 11/19/2010 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date: 10-11-15 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2435

Rev E1

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

10-11-16

8

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
3-Deburr

SL 10/12/07

8

140

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 10/12/07

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63785

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Item ID: D2435

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw, 206

Start Date: 11/12/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

G.A 10/12/07

8

Ø

151

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PPP
63784

C 10/12/08 (8)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/14

MF
10-12-08

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Picklist Print

Monday, November 15, 2010 8:29:17 AM

Page 1

Work Order ID: 63785

Parent Item: D2435

Parent Item Name: Bearpaw, 206



Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	183.2114	3.2	25.6			



UHMW 1" Black



B10-11-16

Location

Loc Qty

Loc Code

MAT

183.2114

114624

5.9054

115325

15.506

115955

161.8

115955

78

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DART AEROSPACE LTD		Work Order:	43785
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.070x45°	✓		Vern 21-3	
B	5.500	+/-0.030	5.505	✓		"	
C	0.200	+/-0.030	.197	✓		"	
D	R0.250	+/-0.030	.250	✓		R-G	
E	0.250	+/-0.010	.256	✓		"	
F	0.625	+/-0.030	.630	✓		"	
G	0.25 x 45°	+/-0.030	.260x45°	✓		"	
H	0.375	+/-0.010	.379	✓		"	
I	19.000	+/-0.030	19.00	✓		m-tape	
J	0.950	+0.030/-0.010	.952	✓		Vern 21-3	
K	Ø0.260	+0.005/-0.000	.260	✓		"	
L	20.930	+/-0.030	925	✓		"	
M	0.30	+0.030/-0.000	.317	✓		"	
N	0.375	+/-0.030	.380	✓		"	
O	7.375	+/-0.030	7.377	✓			
P	4.250	+/-0.010	4.250	✓		CNC-02	
Q	2.000	+/-0.030	2.016	✓		Vern 21-3	
R	9.000	+/-0.010	9.000	✓		CNC-02	
S	15.750	+/-0.030	15.750	✓		m-tape	

Measured by: SL	Audited by: M.A	Prototype Approval:	N/A
Date: 10/12/07	Date: 10/12/08	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	✓

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E1 02.12.17 0.93 WAS 0.75 *FEA*

RELEASED
48 DEC 17 KE

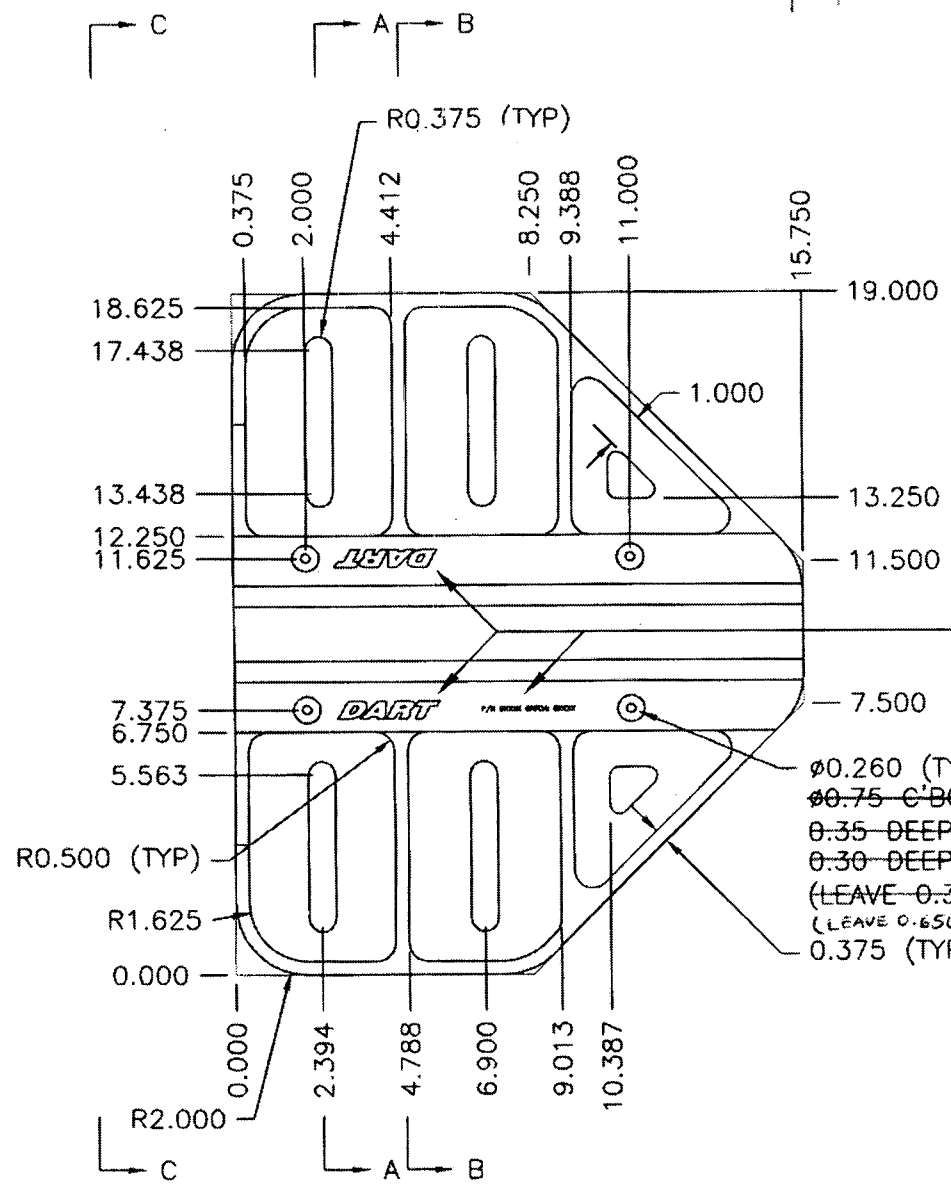
SHIP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBMITTANCE
NOTICE
ORDER
NO. 23785
25-0-11-R



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>KE</i>	
DATE 98.05.19	TITLE BEARPAW	REV. E
		SHEET 1 OF 2
A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50

9143



0.260 (TYP) 0.93 C'BORE
0.75 C'BORE 0.30 DEEP FROM BOTTOM
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375 (TYP)

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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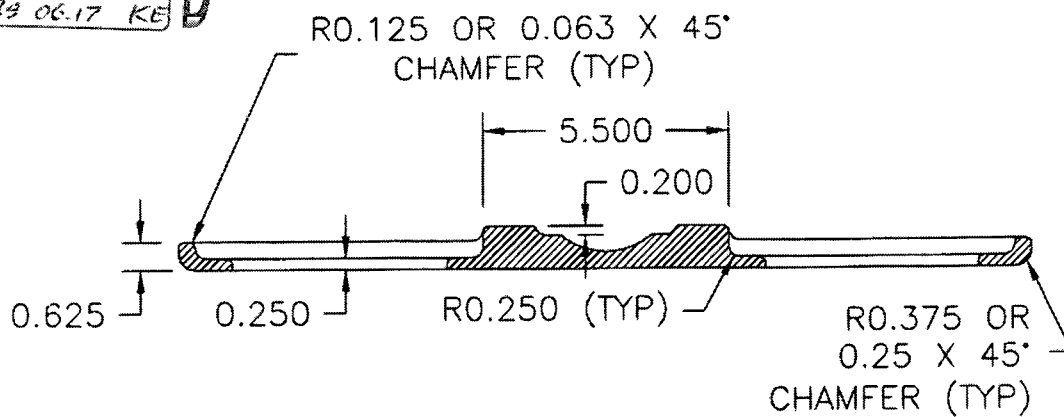
NOTE: Date & initial all entries



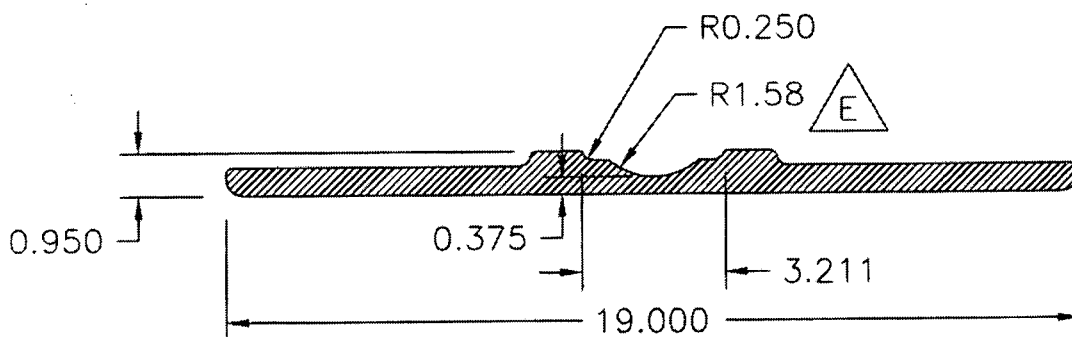
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98 06.17 KE

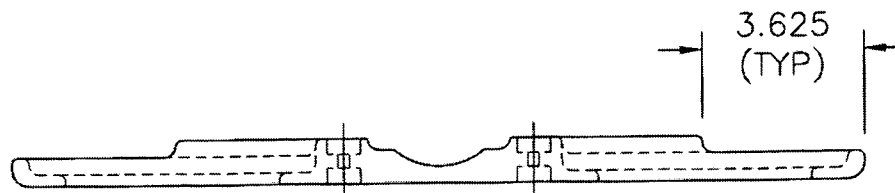
u/b 43755



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
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